

Work Order ID 67602-1

Monday, March 28, 2011 2:27:30 PM

Page 1

Item ID: D3290-3

Revision ID:

Item Name: Window

Start Date: 3/28/2011 Start Qty: 12.00

Required Date: 3/31/2011 Req'd Qty: 12.00

Reference:

Approvals: Process Plan:

QC:

Date: 4-03-28

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3290

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3290
Deburr if necessary

Dwg Rev: C

Prog Rev: C 2-

B11-4-8

18

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-4-8

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/15/08

118

POSITIVE RECALL

EFFECTIVE 11/14/08

RELEASED

AUTH

DATE

11/17/08
CAB

Work Order ID 67602

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Page 2

Item ID: D3290-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Window

Start Date: 3/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

Memo

0.00

0.00

Without removing protective skin remove sharp edge by degurring

x18

DL
11/04/11

140



Thermoform

Thermoforming Machine

THERMOFORMING MACHINE

Memo

1-THERMOFORM as per Drawing D3290 and Folio FTA001 Dwg
Rev C Folio Rev B 2-Engrave part# &
batch# (D3290-3)

0.00

0.00

x18

DL
11/04/11

150



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

x18

DL
11/04/11

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Page 3

Item ID: D3290-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Window

Start Date: 3/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC8- Inspect parts - second check

0 00

Memo

0 00

11 04 14 (18)

170



Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

0.00

Memo

0 00

Water sand and buff to remove scratches if required

x18 Ph 11/04/11

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0 00

Memo

0 00

Swag/h

(18)

Work Order ID 67602

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Page 4

Item ID: D3290-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Window

Start Date: 3/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

SAD 11-04-12

6

Packaging

took 6 windows for w/o B66998

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/12

11-04-12

Picklist Print

Monday, March 28, 2011 2:27:37 PM

Page 1

Work Order ID: 67602

Parent Item: D3290-3

Parent Item Name: Window



Start Date: 3/28/2011

Required Date: 3/31/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A 04.08.18 New issue KJ/RF
IPP B 06.05.09 Ecn 798 EC
IPP C 07.05.29 Thermoform in-house DL
IPP D 07.09.28 rev C dwg EC verified by: DD
IPP E 07.11.28 Add --Hand finish deburring DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS 125		Purchased	No			100	sf	10 0000	3	37.89474	64.		



1/8" Polycast II Sheet



HB11-4-8

Location

Loc Qty

Loc Code

MAT019

10

115338

10

117340

117340

(18)

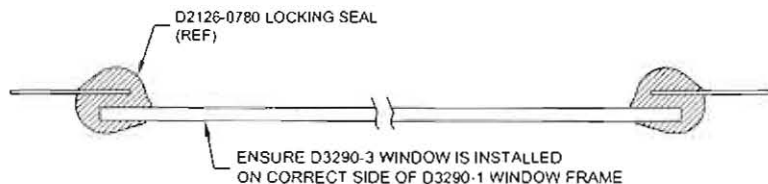
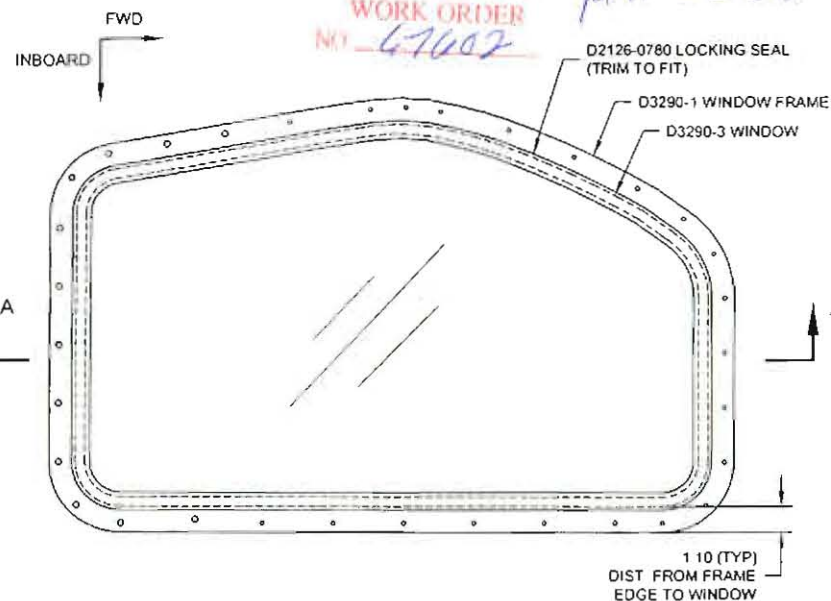
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NOT 67602

PL11-03-20



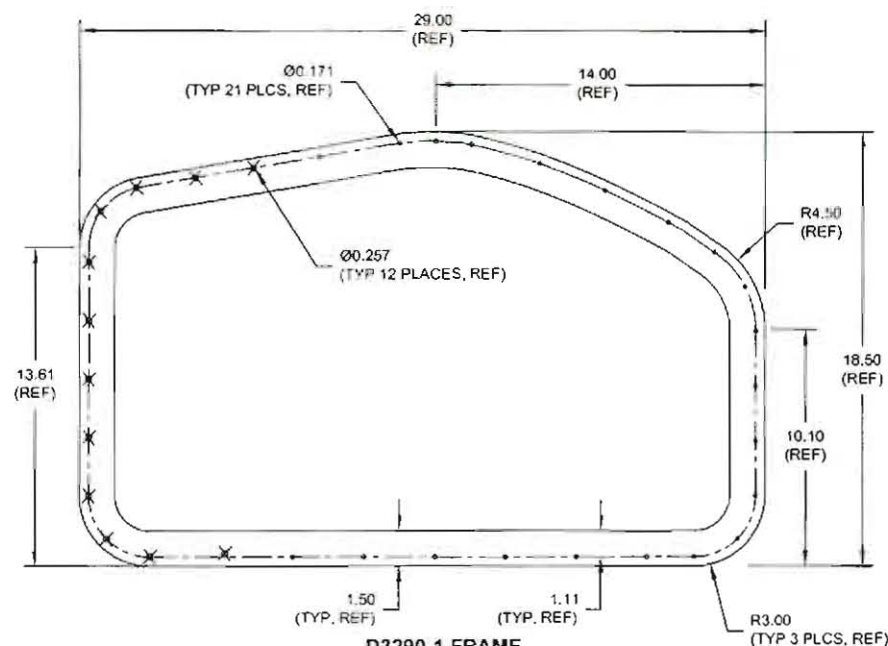
SECTION A-A
NTS

D3290-041 REPLACEMENT WINDOW ASSEMBLY

D3290-041 NOTES:
1) WEIGHT: 3.66 LBS

GENERAL NOTES:

- 1) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED



D3290-1 FRAME

D3290-1 NOTES:

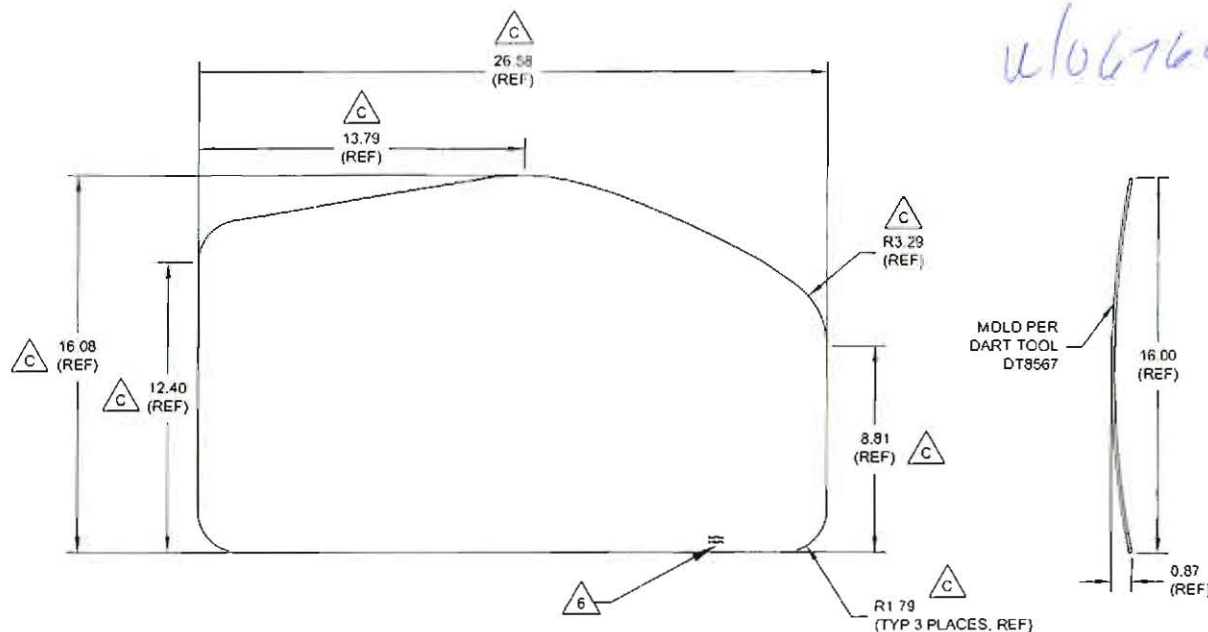
- 1) MATERIAL 6061-T6 (OR 6061-T82) ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.040) OR 5052-H32 ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/8 OR AMS 4016 (REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER OSI C05 4 1 POWDER COAT WHITE (REF. 4.5.3.1) PER DART OSI 005 4 3
- 3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 4) IDENTIFICATION IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.47 LBS

RELEASED
07.07.22
DEO ATTACHED

UNDER REVIEW

405-01-18
MIR 07-05-19

C	UPDATE DIMS PER PAR 188	QC	07.07.21
B	UPDATE MATERIAL PER NCR 029	MB	06.04.20
A	NEW ISSUE	RF	04.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. C
MFG. APPR		D3290	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR		REPLACEMENT WINDOW ASSEMBLY	1.5
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS UNCLASSIFIED AND IS AVAILABLE TO THE PUBLIC WITHOUT LIMITATION. IT IS NOT TO BE USED FOR ANY PURPOSES OTHER THAN THAT FOR WHICH IT WAS ORIGINALLY DEVELOPED.</small>	



D3290-3 WINDOW

D3290-3 NOTES:

- 1) MATERIAL POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S 125)
- 2) FINISH. NONE
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

UNDER REVIEW

**DEO ATTACHED
RELEASED**
07.09.22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR		D3290	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR		REPLACEMENT WINDOW ASSEMBLY	1:5
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD	

DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>97</i>	CHECKED <i>15</i>	MFG. APPR. <i>E</i>	APPROVED <i>140</i>	DE APPR. <i>140</i>			
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21	DATE 09/09/21			

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

u/o 97602

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
 2009-10-09
WTP

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